



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

649.4813
Job Sheet 168839



Part No: 649.4813

Job Qty: 20 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/23/17

Job Tracking No:

Due Date: ~~11/30/17~~ 12/08

Created By: Mario Poulin

Type: SOLD

Description:

Note: 649.4800 REV.D IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM IPP REV:B 17.10.18 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/29/17	11/29/17	0.00	0.00	Purchasing Start up		SC
110	Waterjet	20 pcs	11/29/17	11/29/17	0.00	0.61	Waterjet1		SC
120	QC	20 pcs	11/29/17	11/29/17	0.00	0.00	QC2		SC DAS
130	QC	20 pcs	11/29/17	11/29/17	0.00	0.00	QC8		38
140	Small Fab	20 pcs	11/30/17	11/30/17	0.00	1.25	Small Fab		DAS 0.88
150	QC	20 pcs	11/30/17	11/30/17	0.00	0.00	QC5		38
160	Outsource	20 pcs	11/30/17	11/30/17			ATG001-VC		9-88
170	Packaging	20 pcs	11/30/17	11/30/17	0.00	0.00	Packaging2		22-12-17
180	QC	20 pcs	11/30/17	11/30/17	0.00	0.00	QC5		22-12-17
210	Packaging	20 pcs	11/30/17	11/30/17	0.00	0.00	Packaging3		17-12-22 primer 2.7 mils.
220	QC21-SA	20 Ea	11/30/17	11/30/17	0.00	0.00	QC21		DEC 22 2017

Part Op 110 - 1-Cut as per Dwg Dwg Rev: D1 Prog Rev: D1 2-Deburr if necessary

Descriptions: 140 - FORM AS PER DWG USE DT9855

160 - ISSUE P/O: _____ As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P-23377J Type1 Class N

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.125	1	8	0	0

SC18252

Part Specifications

Specifications could not be found.

Plex 11/23/17 11:45 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By

Job No: 168839
Mfg Date: 12/14/17

Start up Operation

649.4813

PART NO:
Revision:
Operation:
Change No:

and / Supervisor
oval VerificationQA Coordinator
Approval

Root Cause			
Environment ☐	No Re-verification ☐	Pressure ☐	
Design ☐	Operator ☐	Bending ☐	
Doc/Data ☐	Offset/Setup ☐	Centre N ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/K ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : ☐	

Dart Aerospace Ltd.
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TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



DART
AEROSPACE
S022565

Shim

tioned Wrong
side Dimensions
r/Under tolerance
t Incorrect
t Lost/Missing
t Moved
wing
ish
Misread
Turning Sequence

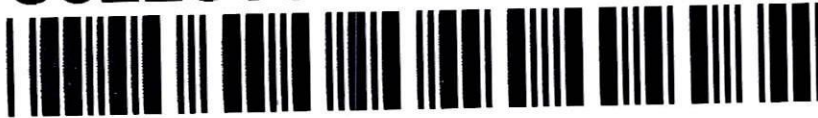
Fit/Function
Misaligned/off center

Instructions Incomplete/Unclear
Drill Holes

DART
AEROSPACE
S022565

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CANADA
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www.dartaerospace.com



Shim

PART NO: 649.4813
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/14/17 Job No: 168839
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Canada

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PURCHASE ORDER PO038682

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			Hard Anodize Black and Prime as Per Dwg 646.3800							
Line Item Note RUSH										
7	168025	646.3813	AS350 Strut Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	12/22/17	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50
Line Item Note RUSH										
8	168239-A	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	6 pcs	0 pcs	6 pcs	\$7.60/pcs	\$45.60
9	168239	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	1/17/18	12 pcs	0 pcs	12 pcs	\$7.60/pcs	\$91.20
10	168280	647.0210	Rail Issue P/O to ATG : AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N	Firmed	1/17/18	11 pcs	0 pcs	11 pcs	\$11.50/pcs	\$126.50
11	168223	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	12/22/17	6 pcs	0 pcs	6 pcs	\$11.65/pcs	\$69.90
Line Item Note RUSH										
12	168839	649.4813	Shim ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P-23377J Type1 Class N	Firmed	12/22/17	20 pcs	0 pcs	20 pcs	\$7.25/pcs	\$145.00
Line Item Note RUSH										
13	169183	649.5212	Bracket Issue P/O to ATG : 1- Hard Anodize Black as per Dwg	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$10.00/pcs	\$50.00

20x 22-12-17 mdf



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914353

Date: 22-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
6 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22199		Rev: N/C PO: PO038682 Line: 11
20 ea	Part: 649.4813 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22200		Rev: D PO: PO038682 Line: 12 ✓
10 ea	Part: 647.7823 Cross Bracket Aft Job: 22204		Rev: PO: PO038682 Line: 16
5 ea	Part: 646.3813 AS530 Strut Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22194		Rev: N/C PO: PO038682 Line: 6
5 ea	Part: 646.3813 AS350 Strut Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22195		Rev: N/C PO: PO038682 Line: 7
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914353

Date: 22-Dec-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/12/17</u> Certified Signature: <u>J.ves Richard</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.